

Date: Friday, 16/05/2008 7:50:14 AM
 User: Linda Lacelle

Process Sheet

23/05
Split
23/05/21

| | | | | | |
|-----------------------|--|--|------------------|---------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : WEARPLATE | |
| Job Number | : 39313 | | Part Number | : D33193 | |
| Estimate Number | : 10606 | | Drawing Number | : D3319 REV. B | |
| P.O. Number | : | | Project Number | : N/A | |
| This Issue | : 16/05/2008 S.O. No. : | | Drawing Revision | : B | |
| Prsht Rev. | : NC | | Material | : | |
| First Issue | : / / Type : SMALL /MED FAB | | Due Date | : 23/05/2008 Qty: 3 | |
| Previous Run | : 38091 | | Um: | Each | |
| Written By | : | | | | |
| Checked & Approved By | : | | | | |
| Comment | : Est: A 05/05/12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|--|
| 1.0 | M1010S18GA | 1010/1025/A21/6aA SHEET .048 50. |
| | | |
| | | Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: 106603 HB 8-5-20 |
| 2.0 | WATER JET | FLOW WATER JET |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B HB 8-5-20 Prog Rev: B |
| | | (14) |
| | | 2-Deburr if necessary HB 8-5-20 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | HB 8-5-20 |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE |
| 4.0 | QC8 | SECOND CHECK |
| | | 5 08/05/20 (X4) |
| | | Comment: SECOND CHECK |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| | | A |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary |
| | | Done at step # 2.2 2008/05/21 |

Friday, 16/05/2008 7:50:14 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SS 08/05/21 (3)

7.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

LARGE FABRICATION RESOURCE 1

8.0 LARGE FAB 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: _____

(3X)

Qty Part Number Description
A/R N/A 7560 Hardcoat Rod

Batch

M106762 08-05-20 SP.

9.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

INSPECT WORK TO CURRENT STEP

10.0 QC5



(X3)

Comment: INSPECT WORK TO CURRENT STEP

11.0 POWDER COATING

POWDER COATING



(3X)

M105642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:45 PM
OVEN TEMPERATURE: 320° F
FINISH TIME: 2:15 PM

m.l 08/05/21

(3)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



3X

Comment: INSPECT POWDER COAT

13.0 PACKAGING 1

PACKAGING RESOURCE #1



SC

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.

8/5/21

Friday, 16/05/2008 7:50:14 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

(3x)

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST.

996

8/5/21

SLP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



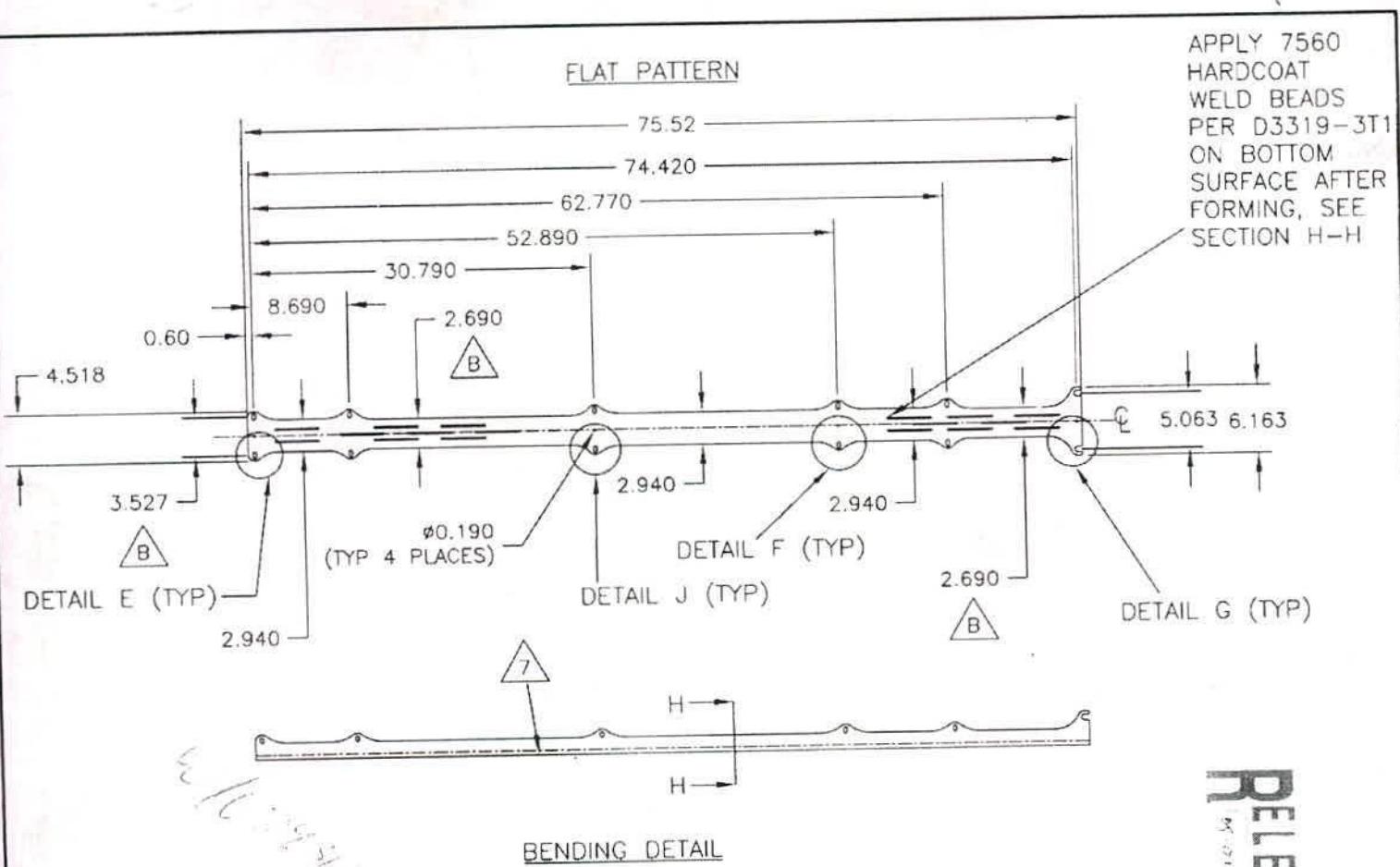
08/05/21 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-21



DART

| | | |
|---------------------|-------------------------|---|
| DESIGN <i>#4</i> | DRAWN BY <i>R.H.</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D3319 |
| DATE 05.06.06 | | TITLE WEARPLATE |
| | | REV. B |
| | | SHEET 2 OF 5 |
| | | SCALE 1:15 |

RELEASED
RE

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

ART AEROSPACE LTD

Work Order: 39313

Description: WEAR PLATE

Part Number: D3319-3

Inspection Dwg: D339-3 Rev: 5

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: HB
Date: 8-5-20

| | |
|-------------|---|
| Audited by: |  |
| Date: | 08/08/20 |

| | |
|----------------------------|--------------------|
| Prototype Approval: | <i>[Signature]</i> |
| Date: | <i>10/10/05</i> |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |